

§ 56.70-3 Limitations.

Backing rings. Backing strips used at longitudinal welded joints must be removed.

[CGD 73-254, 40 FR 40165, Sept. 2, 1975]

§ 56.70-5 Material.

(a) *Filler metal.* All filler metal, including consumable insert material, must comply with the requirements of section IX of the ASME Boiler and Pressure Vessel Code (incorporated by reference; see 46 CFR 56.01-2) and 46 CFR 57.02-5.

(b) *Backing rings.* When metallic backing rings are used they shall be made from material of weldable quality compatible with the base metal, whether subsequently removed or not. When nonmetallic backing rings are used they shall be of material which does not deleteriously affect either base or weld metal, and shall be removed after welding is completed. Backing rings may be of the consumable insert type, removable ceramic type, of solid or split band type. A ferrous backing ring which becomes a permanent part of the weld shall not exceed 0.05 percent sulphur. If two abutting surfaces are to be welded to a third member used as a backing ring and one or two of the three members are ferritic and the other member or members are austenitic, the satisfactory use of such materials shall be determined by procedure qualifications.

[CGFR 68-82, 33 FR 18843, Dec. 18, 1968, as amended by CGD 73-254, 40 FR 40165, Sept. 2, 1975; USCG-2002-13058, 67 FR 61278, Sept. 30, 2002; USCG-2003-16630, 73 FR 65184, Oct. 31, 2008]

§ 56.70-10 Preparation (modifies 127.3).

(a) *Butt welds (reproduces 127.3)(1)—End preparation.* (i) Oxygen or arc cutting is acceptable only if the cut is reasonably smooth and true, and all slag is cleaned from the flame cut surfaces. Discoloration which may remain on the flame cut surface is not considered to be detrimental oxidation.

(ii) Butt-welding end preparation dimensions contained in ASME B16.25 (incorporated by reference; see 46 CFR 56.01-2) or any other end preparation that meets the procedure qualification requirements are acceptable.

(iii) If piping component ends are bored, such boring shall not result in the finished wall thickness after welding being less than the minimum design thickness. Where necessary, weld metal of the appropriate analysis may be deposited on the inside or outside of the piping component to provide sufficient material for machining to insure satisfactory fitting of rings.

(iv) If the piping component ends are upset they may be bored to allow for a completely recessed backing ring, provided the remaining net thickness of the finished ends is not less than the minimum design thickness.

(2) *Cleaning.* Surfaces for welding shall be clean and shall be free from paint, oil, rust, scale, or other material which is detrimental to welding.

(3) *Alignment.* The inside diameters of piping components to be joined must be aligned as accurately as practicable within existing commercial tolerances on diameters, wall thicknesses, and out of roundness. Alignment must be preserved during welding. Where ends are to be joined and the internal misalignment exceeds $\frac{1}{16}$ -inch, it is preferred that the component with the wall extending internally be internally trimmed (see Fig. 127.3) so that adjoining internal surfaces are approximately flush. However, this trimming must not reduce a piping component wall thickness below the minimum design thickness and the change in the contour may not exceed 30°.

(4) *Spacing.* The root opening of the joint shall be as given in the procedure specification.

(b) *Fillet welds (modifies 127.4.4).* In making fillet welds, the weld metal must be deposited in such a way as to obtain adequate penetration into the base metal at the root of the weld. Piping components that are to be joined utilizing fillet welds must be prepared in accordance with applicable provisions and requirements of this section. For typical details, see Figures 127.4.4A and 127.4.4C of ASME B31.1 (incorporated by reference; see 46 CFR 56.01-

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2) and 46 CFR 56.30-10(b). See 46 CFR 56.30-5(d) for additional requirements.

[CGFR 68-82, 33 FR 18843, Dec. 18, 1968, as amended by CGFR 69-127, 35 FR 9978, June 17, 1970; CGD 73-254, 40 FR 40165, Sept. 2, 1975; CGD 77-140, 54 FR 40614, Oct. 2, 1989; USCG-2003-16630, 73 FR 65184, Oct. 31, 2008]

§ 56.70-15 Procedure.

(a) *General.* (1) Qualification of the welding procedures to be used, and of the performance of welders and operators, is required, and shall comply with the requirements of part 57 of this subchapter.

(2) No welding shall be done if there is direct impingement of rain, snow, sleet, or high wind on the piping component weldment.

(3) Sections of pipe shall be welded insofar as possible in the fabricating shop. Prior to welding Class I piping or low temperature piping, the fabricator shall request a marine inspector to visit his plant to examine his fabricating equipment and to witness the qualification tests required by part 57 of this subchapter. One test specimen shall be prepared for each process and welding position to be employed in the fabrication.

(1) Girth butt welds must be complete penetration welds and may be made with a single vee, double vee, or other suitable type of groove, with or without backing rings or consumable inserts.

(2) Girth butt welds in Class I, I-L, and II-L piping systems shall be double welded butt joints or equivalent single welded butt joints for pipe diameters exceeding three-fourth inch nominal pipe size. The use of a single welded butt joint employing a backing ring (note restrictions in paragraph (b)(3)(iv) of this section) on the inside of the pipe is an acceptable equivalent for Class I and Class II-L applications, but not permitted for Class I-L applications. Single welded butt joints employing either an inert gas for first pass backup or a consumable insert ring may be considered the equivalent of a double welded butt joint for all classes of piping and is preferable for Class I-L and II-L systems where double butt welds cannot be used. Appropriate welding procedure qualification tests shall be conducted as specified in

part 57 of this subchapter. A first pass inert gas backup is intended to mean that the inside of the pipe is purged with inert gas and that the root is welded with the inert gas metal arc (mig) or inert gas tungsten arc (tig) processes. Classes I, I-L, and II-L piping are required to have the inside of the pipe machined for good fit up if the misalignment exceeds that specified in § 56.70-10(a)(3). In the case of Class II piping the machining of the inside of the pipe may be omitted. For single welded joints, where possible, the inside of the joint shall be examined visually to assure full penetration. Radiographic examination of at least 20 percent of single welded joints to check for penetration is required for all Class I and Class I-L systems regardless of size following the requirements of § 56.95-10. Ultrasonic testing may be utilized in lieu of radiographic examination if the procedures are approved.

(3) For Class II piping, the type of joints shall be similar to Class I piping, with the following exceptions:

(i) Single-welded butt joints may be employed without the use of backing rings in all sizes provided that the weld is chipped or ground flush on the root side of the weld.

(ii) For services such as vents, overflows, and gravity drains, the backing ring may be eliminated and the root of the weld need not be ground.

(iii) Square-groove welds without edge preparation may be employed for butt joints in vents, overflows, and gravity drains where the pipe wall thickness does not exceed three-sixteenth inch.

(iv) The crimped or forged backing ring with continuous projection around the outside of the ring is acceptable only for Class II piping. The projection must be completely fused.

(4) Tack welds which become part of the finished weld, shall be made by a qualified welder. Tack welds made by an unqualified welder shall be removed. Tack welds which are not removed shall be made with an electrode which is the same as or equivalent to the electrode to be used for the first pass. Their stopping and starting ends must be properly prepared by grinding or other suitable means so that they may be satisfactorily incorporated into the